QC8- Inspect parts - second check

Memo

Quality Control

t-	Del	rin 1,000'	Manual Ma										
Work Ord November-11-1.				*	109	094*							Page
Item ID: Revision ID:	D3183-045		1	Accept		*N900	040	100) * s	Setup	Start	*N	S1*
Item Name:	Bearing Assem	nbly				•					Stop	*N	S2*
Start Date: Required Date: Reference:	11/11/13 11/25/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*			Cust Item II Customer:	D:						
Approvals:		n: MLJ	Date: 13-11-11 Date:	Tooling:			te:		Į	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set U Run I	p/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr											
D3183	Rev	C1											
1 nn Hardinge CNC Lath	e Small	Hardinge CNC LATHE S Memo Turn D3183-	SMALL 9 Cap as per Folio FA388D	0.00 0.00 eburr	F.K.	13/11/12	· v		40	9	s		
110 *110* QC Quality Control		QC2- Inspect parts off ma	achine FAI/FAIB	0.00	F.K,	13/11/15			40	_ J	5		

0.00

QAS 13/11/16

40 Ø

DQA:			Date:										TQART
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
						DISPOSITION			AGAINS	T DE	PARTMENT,	PROCESS	
Work Orde	r: -								a	_	1	\A/atau lat	¬
						Rework		j ,	Skid-tube Crosstub	_	Dun	Water Jet	Engineering
Part N	10.					Scrap			Machining Small Fa	_	4	d. Eng. Coor. e/Packaging	Quality Other
NCR N	۱۵					Use-as-is Suspected Unapproved		mern	Large Fab Composit		Nec/3101	Supplier	
NCKI	١٥					Suspected Onapproved	<u>ا</u> ا		Laige Faul Composit	·	j	2dppnet	ا لــا
Root					Desc	ription of work order update	П	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance		ief Eng			Date	Verification	QC Inspector
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Doc/Data													
Equip/Tooling	\neg					· !							
Handling/Pre													
Material							ĺ						•
Operator													
Offset/Setup									1				
Process													
Supplier			<u> </u>				١		!				
Training													
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Unapproved		•					<u> </u>						
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Landi		1			_	General	_	1			7		······································
		Bending			-	Bend	<u></u>	4	Program	_	Outside Dim	 	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	<u></u>	Grain		<u> </u>	Over/Under	<u> </u>	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorred	⊢	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		4 '	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld
		Cuffs			<u> </u>	Contamination		4	tions Incomplete/Unclear	-	Part Moved		Wrong Stock Pulled
	<u> </u>	Crushing				Countersink	\vdash	•	gned/off center	-	Positioned V	_	٦
		Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislab		L	Power Loss/	Surge	Other
	\vdash	Inspection		Tube		Drawing	\vdash	Misrea					
	\vdash	Marks/Ch			\vdash	Drill Holes	\vdash	Off-set				·· ··	
	<u> </u>	Turning S	-		-	Finish Fit/Function	\vdash	4	Calibration Sequence		•		

Work Orde				*109	N94*							Page 2	· ,
Item ID: Revision ID: Item Name:	D3183-045 Bearing Asser	nbly		Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1*	
Start Date: Required Date: Reference:	11/11/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	I D :				•	TN.	S2*	
Approvals:		in:	Date:	Tooling: SPC (Y/N):		ate:		וֹ	Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab		Operation Description Small Fab Memo Press D3183	-5 Bearing into D3183-9 C	Set Up/ Run Hours 0.00 0.00 Cap as per Dwg D3183.	Tool ID	Tool #	Plan Code	Accept Qty 40x	Qty		Reject Number	Insp. Stamp	DA 36 9-89 20
140 *140* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00 DAS 0.00 27 9-89 0.00 J	.0		(40,					
*150 *150* Packaging		Identify as per dwg & Sto	ock Location:873	5B.00				40X				1311	;-)C

DQA:		<u>. </u>	Date:										TQ AC
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	·	!				DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Work Orde	-	 .				Rework	1		Skid-tube Crosstube			Water Jet	Engineering
Part N	do.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
""	•••					Use-as-is			moforming Finishing	_		e/Packaging	Other
NCR I	No.					Suspected Unapproved		.,,,	Large Fab Composite	-	,	Supplier	1 1
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Root					Desc	ription of work order update	l	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC inspector
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		Bending Centre No	at Cancar	atria	\vdash	BOM/Route	\vdash	Grain	riogialli	H	Over/Under	<u> </u>	Set-up
	\vdash	Cracks	or concer	itric		Broken/Damage/Defect	\vdash	Hardwa	ara	\vdash	Part Incorred	—	Temperature/Cure
	-	Cracks Crimp/Kir	nk/Rinnla	/\/\ave	\vdash	Burrs	-	4	tion Incomplete/Unqualified	\vdash	Part Lost/Mi	<u></u>	Weld
i i	┝	Cuffs	ik/ wibbie	y wave		Contamination	-	1 .	tions Incomplete/Unclear	-	Part Moved	-	Wrong Stock Pulled
	⊢	Crushing			-	Countersink		4	gned/off center		Positioned V	L Vrong	
	\vdash	Heat Trea	ıt			Cut Too Short		Mislab	=		Power Loss/		Other
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		Wave/Tw				Fit/Function		4	Sequence				

Work Ord November-11-1				*109	0094*						Page :	3
Item ID: Revision ID:	D3183-045			Accept	*N900	040	100	* Set	up Star	* * N	S1*	
Item Name:	Bearing Asse	embly							Stop	*N	S2*	
Start Date: Required Date: Reference:	11/11/13 : 11/25/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item 1 Customer:	ID:						
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:		Ru		I/I	R1*	
	QC:		Date:	_ SPC (Y/N):	D	ate:			Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	-	Reject Qty	Reject Number	Insp. Stamp	
*160		QC21- Final Inspection -	Work Order Release	0.00					Rn	1 /3/11	120 .	
QC		Memo		0.00							, - · -	-

Quality Control

DQA:			Date:										TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
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Part N	lo.				•	Scrap	1 1		Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		moforming Finishing	Г	Rec/Sto	re/Packaging	Other
NCR N	lo.					Suspected Unapproved]		Large Fab Composite			Supplier	
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Root		_	_		Desc	ription of work order update	1	nitial	Action		Sign &	N / 1 - 15° 1° - 1 - 1	0612222
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Offset/Setup Process													
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		Centre No	ot Concer	ntric		BOM/Route	L	Grain			Over/Under	<u> </u>	Set-up
		Cracks				Broken/Damage/Defect		Hardw	are	_	Part Incorre	 	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	_	Inspect	tion Incomplete/Unqualified		Part Lost/M	issing	Weld
		Cuffs				Contamination		-	tions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled
	_	Crushing			<u> </u>	Countersink	<u></u>	-	gned/off center	L	Positioned V	_	-
		Heat Trea			L	Cut Too Short	\vdash	Mislab			Power Loss/	Surge	Other
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	L	Turning S	-		<u> </u>	Finish	_	4	Calibration				
	1	Wave/Tw	ist in Tut	oe e		Fit/Function		Out of	Sequence				

Page 1

November-11-13 1:49:48 PM

Work Order ID: 109094

109094

Parent Item:

D3183-045

D3183-045

Parent Item Name: Bearing Assembly

Start Date: 11/11/13

Required Date: 11/25/13

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP A04.02.18New issueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5 *D3183-5* Bearing		Manufactured	No			110	Each	47.0000	1 **	40	13/11	120	D _{AS} 36 9 ₈₉
				Location		Loc :	<u>Oty</u>	Loc Code			• •	,	
				ST235			1						
					106275		1		_				:
				ST235B			46						
					107706		44			40			
					98653		2		_		-		
MDELRINR1.000		Purchased	No			130	f	33.4600	0.0333	2			
MDFI RIN	IR1 000)							**				

Delrin Round Bar 1"

Location	Loc Qty	Loc Code		
MAT	1.46		<u> </u>	
m126794	1.46			
MAT018	32			1. 1
¥ m127442	32		10 Ce Ce	F.K 13/11/15

DQA:			Date:										
						WORK ORDER NON-	-CC	NFO					AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only	
March Onda						DISPOSITION		٠	AGAINST	DE	PARTMENT	PROCESS	
Work Orde	er: -			-		Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	ما					Scrap			Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
raiti	٠٠.				_	Use-as-is			noforming Finishing	_	ı	re/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite		,	Supplier	
	•						'						
Root					Desc	ription of work order update	1	nitial	Action		Sign &	-	
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Landi	nø (Gear				General		<u> </u>					
	_	Bending				Bend	Г	 Folio/I	Program		Outside Dim	ensions	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric		BOM/Roúte	一	Grain	ŭ		Over/Under	tolerance	Set-up
	Г	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	_
	\Box	Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set	:				***************************************
		Turning S	equence			Finish		-	Calibration				
		Wave/Tw	vist in Tub	oe .		Fit/Function	L	Out of	Sequence				

DART AEROSPACE LTD	Work Order:	109094
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension				
Ø0.830	+/-0.005	, \$30 e	7		F4-09	Mic.
Ø0.720	+/-0.002	~720	7		FK-04	Vern.
Ø0.747	+/-0.001	e747	7		85	h .
R0.010	+/-0.010	010	7		R-G	
R0.031	+/-0.010	1800	7		R-G	
0.199	+/-0.001	199	7		FK-04	Ven.
0.276	+/-0.010	6275°)		15	(1
0.039	+/-0.010	.039	70		h	•
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Measured by: Audited by: 9-89 Prototype Approval: N/A

Date: 13/11/15 Date: 13/11/16 Date: N/A

	Rev	Date	Change	Revised by	Approved
-	Α	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
	В	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	
				, CI	<i>,,,</i>

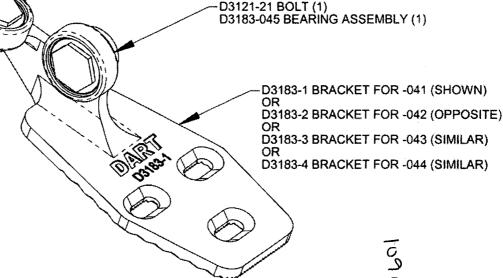




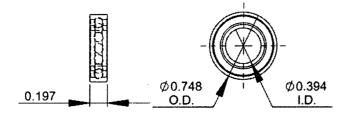
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١	CHECKED		APPROVED	DRAWING NO.	REV. C		
/			#	D3183	SHEET 1 OF 4		
	DATE		A constitution consistent	TITLE	SCALE		
	04.02)2.17	BRACKET ASSEMBLY	1:1		
	A. 03.01.24		3.01.24	NEW ISSUE			
	В	0:	3.06.17	REMOVE BEARING; 1.012 WS 0.882			
	<u> </u>		4.02.17	ADD -045/-9; 0.182 WAS 0.431			
			04.11.09	0.830 WAS 0.850			

DEO ATTACHED

D3121-21 BOLT (1) D3183-045 BEARING ASSEMBLY (1)

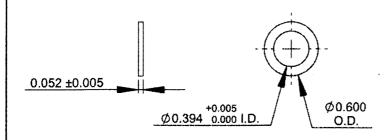


D3183-041 BRACKET ASSEMBLY (SHOWN) D3183-042 BRACKET ASSEMBLY (OPPOSITE) D3183-043 BRACKET ASSEMBLY (SIMILAR) D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

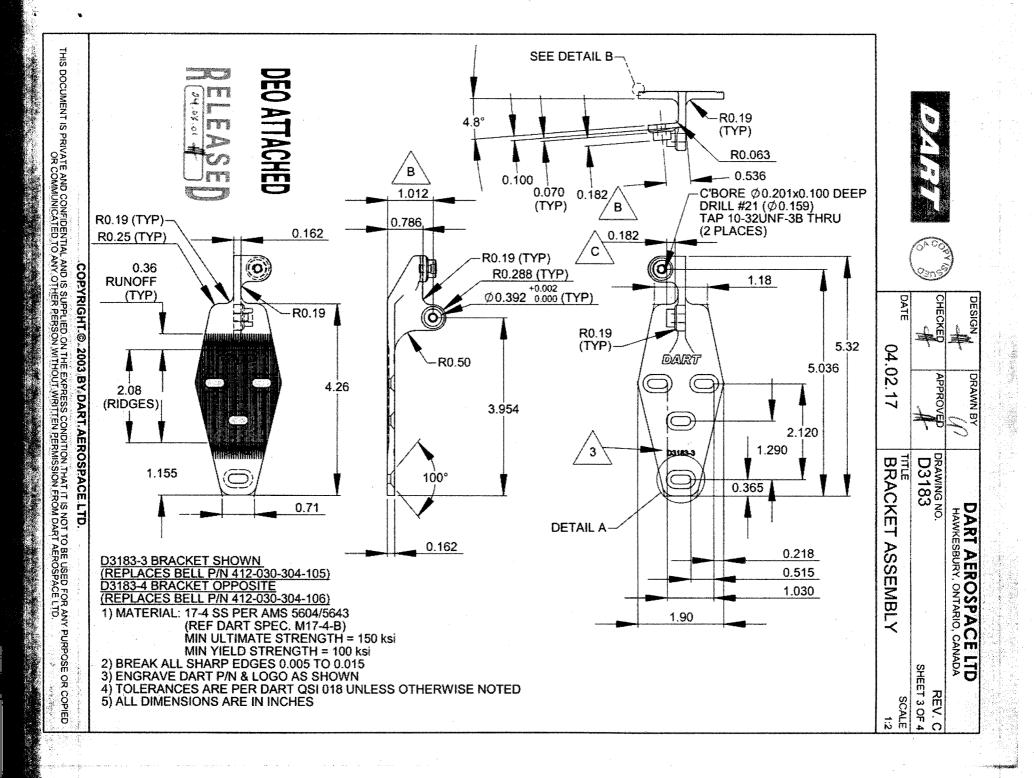


D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) **ANNEALED**
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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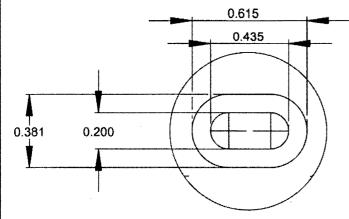


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CHECKED	APPROVED	D3183	REV. C SHEET 4 OF 4		
DATE	00.47	TITLE DOACKET ACCEMBLY	SCALE		
1 (14)	02.17	□ BRACKET ASSEMBLY	1:1		

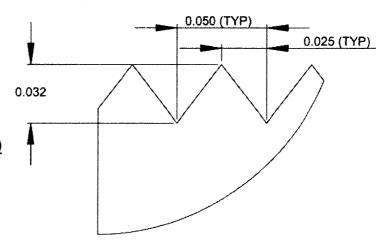


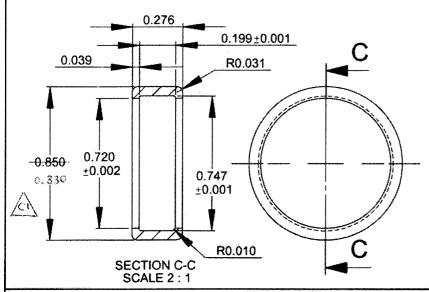
DETAIL A (2:1)

RELEASE DOULES ON A STATE OF THE STATE OF TH

DEO ATTACHED

DETAIL B (20:1)





D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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DRAWING	NO. TITLE		, REV.C1	DART AEROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D3183	BRACKE	ET ASSEMBLY		ENGINEERING ORDER	D3183-C1-1	SHEET 1 OF 1	NTS
DRAWN	P	CHECKED	丛	MFG. APPR.	APPROVED W	DE APPR.	
DATE	10.05.14	DATE	10.06.30	DATE (8,06,30	DATE 10/06/30	DATE 10/06/30	

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT:

Cr = 1720 N (386 lb) MIN [DYNAMIC]

Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012



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